

Date: Tuesday, 01/04/2008 3:45:00 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE BLOCK
<b>Job Number</b> :	38274		
<b>Estimate Number</b> :	10324		
<b>P.O. Number</b> :		<b>Part Number</b> :	D1049
<b>This Issue</b> :	01/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D1049 REV A
<b>First Issue</b> :	01/04/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36465	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	24/04/2008
<b>Written By</b> :		<b>Qty:</b>	50
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	JO 08.04.01		
<b>Comment</b> :	Est RevC 02.04.10 Re-format NG		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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**Comment:** Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)

Material: 6061-T6 bar .750 wide x .250 thick.

Batch M1107904

*M.A 08/05/21*

2.0	SHEAR	SHEAR
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**Comment:** ~~SHEAR~~ **BAND SAW**

Cut Blanks: 2.000" long

*M.A 08/05/21*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

*J.L 08/06/02*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 08/06/02*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*J.L 08.06.01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:45:01 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 38274

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten: RB/F*

*Handwritten: 50*

*Handwritten: 30 min*

09/06/2008

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*Handwritten: M105642*

S.298 10.51

#1 318.6 F

#2 *Handwritten: 1338827*

#3 *Handwritten: 01044*

#4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten: 08/06/09 (50)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Handwritten: STQ*

*Handwritten: AS 08/06/09 (50)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 08/06/10*

Job Completion



*Handwritten: 08-06-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

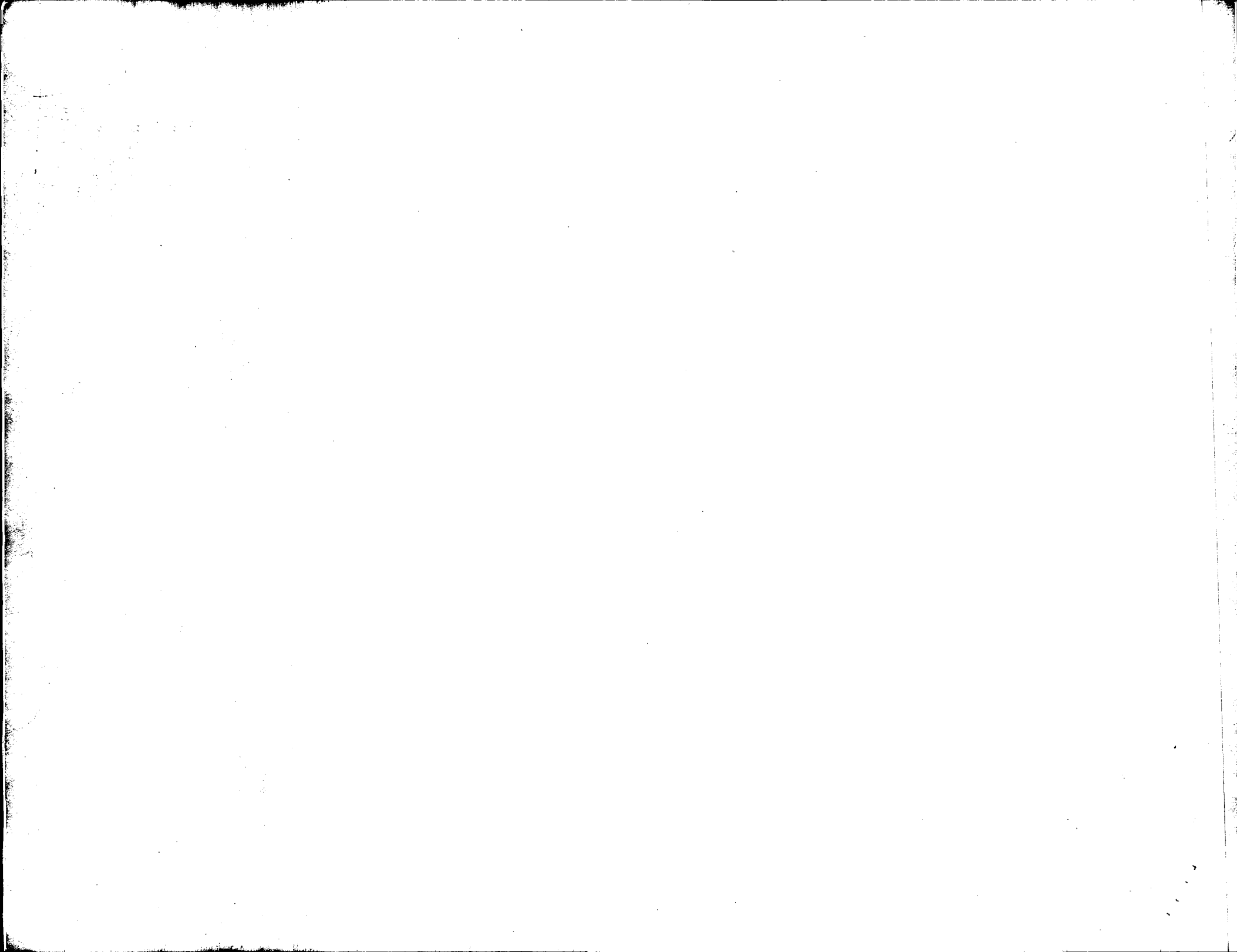
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

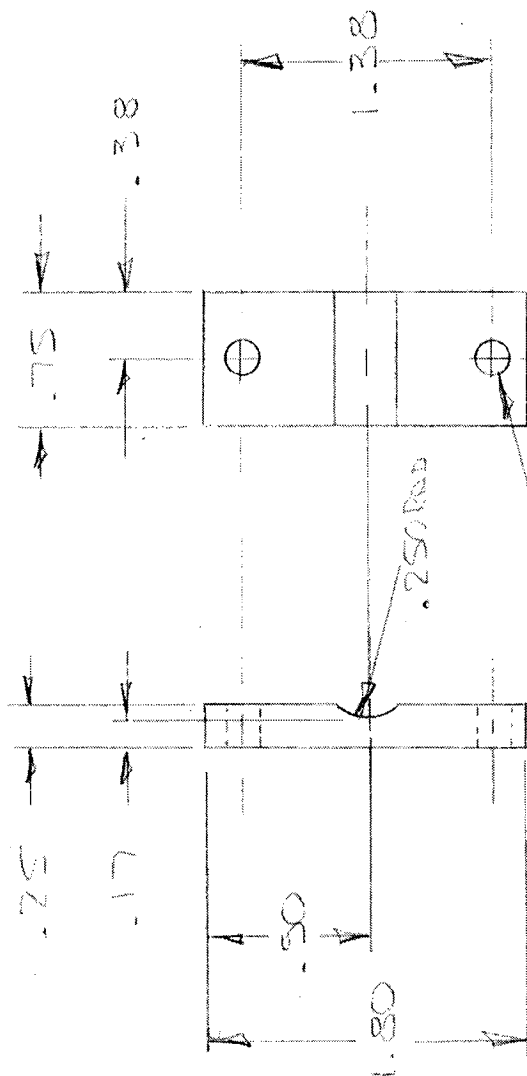
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





9710802 B2



203 DIA. TIT

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NO. 38724

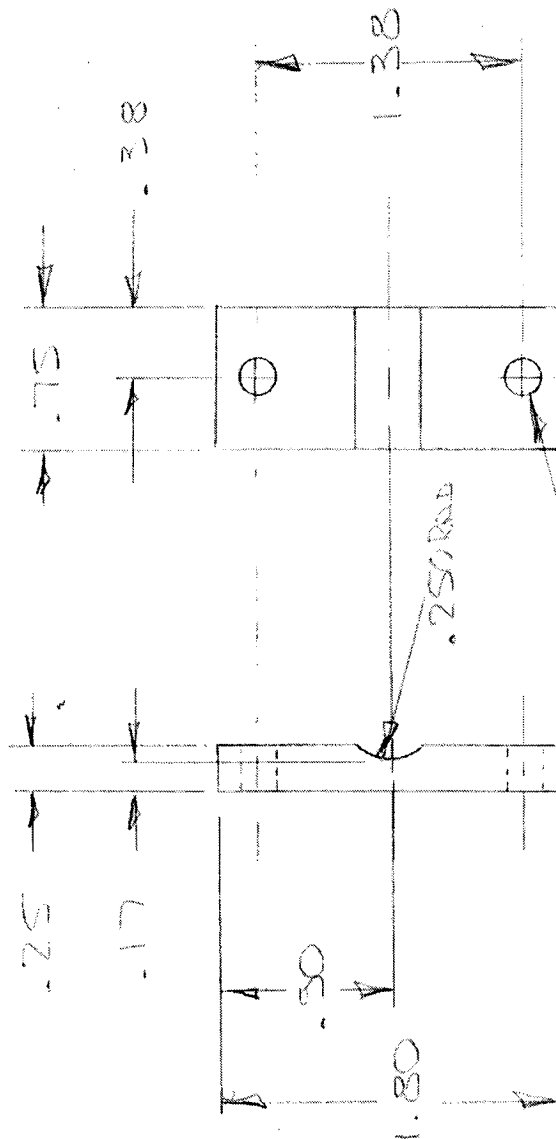
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RELEASED

9710402 B3



203 DIA  
TYP

MATERIAL: 5052-H32

FINISH: POWDER COAT

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WITHOUT NOTICE  
WORK ORDER  
NO. 38724



REVISION		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC. APPROV.	
DRAWN		CONTRACT NO.						DART		DART AERO ACCESSORIES INC. VANCOUVER	
APPROVED		DRAWN		DATE							
		DESIGN		DATE							
		STRESS								TITLE SADDLE	
		CHECKED								DWG NO D1049	
		CLEN								REV	
										SHEET OF	

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPO ON COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

1. DIMENSIONS ARE IN INCHES	1. TOLERANCES —
2. SURFACE FINISHNESS —	XXX ± .010
3. REMOVE BURRS EDGES .015 MAX	XXX ± .005
4. HOLE DIA ± .005	XXX ± .0025
5. HOLE PER AND TOLER	XXX ± .001

REPORT ALL DISCREPANCIES — DO NOT SCALE

